•		
Work	Order ID	50097

. July 08, 2009 11:13:02 AM

Item ID: D3145-2 Accept Setup Start **Revision ID:** В Stop **Item Name:** Bracket **Start Qty: 10.00 Start Date:** 7/10/2009 **Cust Item ID:** Required Date: 7/31/2009 Req'd Qty: 10.00 **Customer:** Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Draw Plan Reject Reject Draw Accept Insp. Work Center ID Description Qty Number Rev. Code Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D3145 Rev B 100 0.00 **BAND SAW** Bandsaw 0.00 Memo Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar Jeaspa Bandsaw 110 0.00 HAAS CNC VERTICAL MACHINING #1 HAAS 1 0.00 HAAS CNC vertical machine #1 Machine per Folio FA318 and Dwg D3145 □ Deburr and Tumble

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Page 1

Dart Aerospace L

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W/O:			WC	RK ORDER CHANGE	S		<u></u>		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date:	
		olution:							
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCR)	•		
DATE	STEP	Description of NC			Verifica				Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Section	Section C Chief Eng	Chief Eng	QC Inspector
<u>-</u>									
				-					

Work Order ID 50097

· July 08, 2009 11:13:02 AM

Item ID:	D3145-2			Accept				Se	etup Sta	rt		
Revision ID:	В								- 04			
Item Name:	Bracket								Sto	p		
Start Date:	7/10/2009	Start Qty: 10.00			Cust Item II) :						
Required Date:	7/31/2009	Req'd Qty: 10.00			Customer:							
Reference:												
Approvals:	Process Pla	n:	Date:	Tooling:	Dat	te:		R	un Sta			
	QC:		Date:	SPC (Y/N):	Dat	te:			Sto	p		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130		QC8- Inspect parts - secon	nd check	0.00								
QC		Memo		0.00	,				_0_			
Quality Control		Memo		and	04/07/20	,						
				,								
140		Chemical Conversion Coa	at per QSI005 4.1	0.00 UNO	09/07/6	20						
HandFinish		Memo		0.00	,			XIQ)	-			
Hand Finishing		Memo										
150		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00 0.00 _□OVEN TEMPERATURE:			(B)					
Powdercoat				000	1000	72	9,	· · · · · · · · · · · · · · · · · · ·				
Powder Coating		Memo S T ART TIMI	e: 8:00	OVEN TEMPERATURE:	Oper	<i>∞</i>)						
		300°	E: S. <u>ØØ</u> DFINISH TIME:	\$.30								
				-								

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W/O:			WC	RK ORDER CHANG	ES				,		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	ApprovaJ QC Inspector		
								į			
·											
Part No							o DQA: Date:				
	Re	esolution:						Date: _			
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCF	?)					
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description				cation	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC inspector		
10,1											
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July	ΩR	2009	11:13:02	ΔM
эшу	vo,	2009	11.15.02	AUVI

Item ID:	D3145-2			Accept				S	etup Sta	rt	
Revision ID: Item Name:	B Bracket								Sto	p	
Start Date: Required Date:	7/10/2009 7/31/2009	Start Qty: 10.00 Req'd Qty: 10.00			Cust Item II Customer:	D:					
Reference:			·								
Approvals:	Process Plan:		Date:	Tooling:	Da	ite:		Run Start			
			Date:	SPC (Y/N):	Date:			Stop			
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		QC3- Inspect Part Finish		0.00	507/00/	02	,		6		
QC Quality Control		Memo		0.00	0000	83	(100	P		
170	,	Identify as per dwg & Stoc	k Location: <u>67</u>	0.00				/	2	,	
Packaging Packaging		Memo		0.00				_(``	E/7/	727	(10)
180		QC21- Final Inspection - V	Work Order Release	0.00				09l	07/2	74	
QC		Memo		0.00				*****			
Quality Control								<i>II</i>	d1.8	7.24	

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W/O:			WO	RK ORDER CHANGE	S				, ,
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							į		
· · · · · · · · · · · · · · · · · · ·									
Part No: PAR #:			Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMAN	NCE (NCF	R)			- -
DATE	STEP	Description of NC				Verific	ication Approval		Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
						į			

July 08, 2009 11:13:02 AM

Work Order ID: 50097

Parent Item:

D3145-2RevB

Parent Item Name: Bracket

Comments:

Start Date: 7/10/2009

Required Date: 7/31/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6B2.000X02.00		Purchased	No		100	f	30.0000	4.0347			

6061-T6 Bar 2.00 x 2.00

	<u>Warehouse</u>	Loc Oty	Loc Code	
	Location			
	Main Warehouse			
,	MAT	30		
	110167	2.36		
palozhy	13085	12		
1179	17124	15.64	17124	4.0347

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W/O:			V	ORK ORDER CHAN	GES					
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	ApprovaJ QC Inspector			
							:			
Part No		PAR #:	Fault Cat	tegory:	NCR: Yes	No DQ	A :	Date:		
	Res	solution:	Dispositi	ion:	QA: N/C CI	QA: N/C Closed: D				
NCR:		\	WORK ORI	DER NON-CONFORM	MANCE (NCF	?)				
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Description		ection B Sign & Date			Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng	Date					

DART AEROSPACE LTD	Work Order:	50097
Description: BRACKET	Part Number:	D3H5-2
Inspection Dwg: Rev:		Page 1 of 1

	FIRST	r article in	SPECTION	ON CHE	CKLIST		
	2	First Artic	:le	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	C	omments
0,240	±0,010	0.245					
RO.250	±0,010	0,250				(2P	LCS)
0,180	±0,010	0,1815					
1,250	±0,010	1.250					
1,960	±0,010	1.963					
\$.221 x 0.351	10,010/10,010	0,218xo.34				Slo	<i>t</i>
28.9°	± 1/2°	28.9°	V .				
0,108	+0,010	0,10					
Ro.330	010,0±	0.330					
RO.188	70'010	0.1875	/			TY	P
0.125	±0,010	0.131				TY	P
1.636	±0,010	1.637				RE	F
95°	± 1/2°	950					
0.125	±0,010	0.125					
0,219	±0,010	0.210				·	
RO,125	±0,010	0.125					
Ro.387	±0,010	0.387					
0.766	70'010	0.766				RE	F
0,250	±0,010	0,252				•	
1.370	±0,010	1.370					
0.760	±0,010	0.760					
4.303	±0,010	4303				RE	F
leasured by:	动户	Audited by:	ms		Prototype Ap	proval:	N/A
Date:	9/07/14	Date: 2	09/07/	(20		Date:	N/A
Rev Date	Change		•		Re	vised by	Approve

			7 /		•			
F	Rev	Date	Change		•		Revised by	Approved
	Α		New Issu	ie		,	KJ/JLM	

Dart Aerospace Ltd

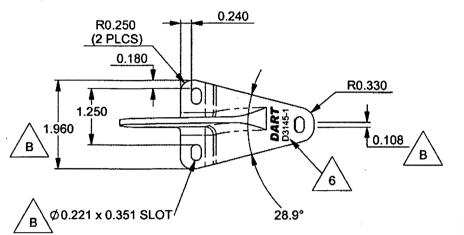
W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
				,							
Part No	:	PAR #: Fault Category:	NCR: Ye	s No DQ	A :	_ Date: _					
			QA:	N/C Close	d:	Date:					

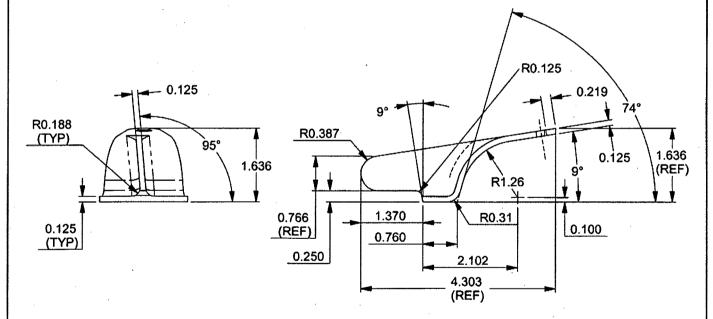
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	-	Corrective Action Section B		\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\						
DATE	STEP	Section A	Initial Chief Eng			Verification Section C	Approval Chief Eng	Approval QC Inspector				
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DESIGN DRA		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED A		APPROVED	D3145 RE	V. B			
03.02.06			BRACKET s	CALE 1:2			
Α	02.04.24		NEW ISSUE				
В	0	3.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000				







D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25 (D3145-2 BRACKET OPPOSITE, REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROC	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					ļ			***************************************		
		PAR #:								
Resolution:			_ Disposit	_ QA: N/	QA: N/C Closed: Date:					
NCR:		W	WORK ORDER NON-CONFOR							
DATE	STEP	Description of NC			ion B	ign &	Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section C		Chief Eng	QC Inspector
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